

Work Order ID 139111

November 13, 2015 2:02:34 PM

139111

Page 1

Item ID: D212-725-1-055

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Angle

Start Date: 11/13/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/23/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: SH

Date: 20151112

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4220

A

100

0.00

100

Small Fab

Memo

0.00

Small Fab

1-Cut as per dwg

~~2-Drill holes as per dwg~~

3-Make radius as per dwg and deburr

15-11-18

1 FF NOV 18 2015

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

D 38 9-89

NOV 18 2015

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

1 15-11-2015 AL

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Page 2

Item ID: D212-725-1-055

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Angle

Stop

NS2

Start Date: 11/13/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/23/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

15.11.18

Memo

0.00

Quality Control

DAS
38
0.89

NOV 20 2015

140

Identify as per dwg & Stock Location: S7577 0.00

140

Packaging

Memo

0.00

Packaging

1 MLJ 15-11-24

150

QC21- Final Inspection - Work Order Release 0.00

150

QC

Memo

0.00

Quality Control

MLJ 15-11-25

MLJ 15-11-24

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Picklist Print

November 13, 2015 2:02:39 PM

Page 1

Work Order ID: 139111

139111

Parent Item: D212-725-1-055

D212-725-1-055

Parent Item Name: Angle

Start Date: 11/13/2015

Required Date: 12/23/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.10.28 as per dwg revF DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3A1.250X1.0X. 063		Purchased		No			f	3.6000		0.7			

M2024T3A1 250X1 0X 063

2024T3511 ANGLE 1.250" X 1" X .063"W

**

FF

NOV 18 2015

Location

Loc Qty

Loc Code

MAT051

3.6

116085

3.6

0.7

DQA: _____ Date: _____

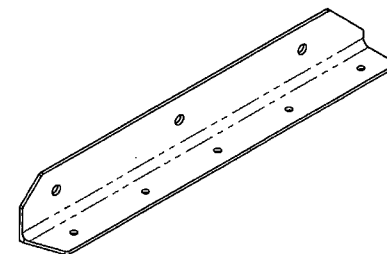
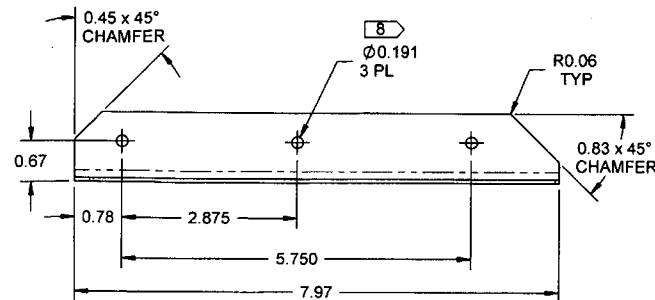
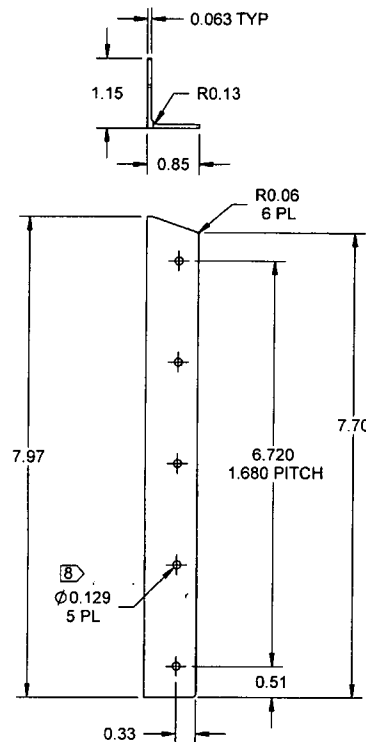


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Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																						
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																						
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																						
				OTHER :																																																																					



RELEASED
2011-08-25
JMD

D212-725-1-055 ANGLE

20151112

SH 139111

NOTES:

- 1) MATERIAL: 2024-T3/T3510/T3511 ALUMINUM ANGLE
PER QQ-A-200/3
OR AMS 4152, 4164 & 4165
PER DART SPEC. M2024T3A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.10 lbs
- 8) DIMENSIONS BETWEEN HOLES ARE PROVIDED FOR REFERENCE ONLY.
TRANSFER Ø0.129, Ø0.191 HOLES FROM AIRCRAFT

DESIGN	RF	DART AEROSPACE	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4220	SHEET 3 OF 4
APPROVED	RF	TITLE	
DE APPR.	RF	SUPPORT BRACKET	
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